

SHIP 26 Sept

Work Order ID 166276

166276

Page 1

Thursday, September 14, 2017 10:24:01 AM

Item ID: D205-633-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00

1

Customer:

Reference:

SEP 13 2017

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D205-633

C

SEP 15 2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D205-633-023 CHG001

DAS
27
9-89

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SEP 19 2017

SEP 15 2017

DAS
6
9-89DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

SEP 26 2017

B# 166278x1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																				
OTHER : ☐																									

Work Order ID 166276

Thursday, September 14, 2017 10:24:01 AM

166276

Page 2

Item ID: D205-633-023**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible**Start Date:** 9/19/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/26/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-023 Location : FG082								
	<i>Sold</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

SEP 26 2017

DAS
21
9-89

SEP 26 2017

DAS
21
9-89

SEP 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, September 14, 2017 10:24:00 AM

Page 1

Work Order ID: 166276

166276

Parent Item: D205-633-023

D205-633-023

Parent Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue Rev B dwg 07-11-19 DD verified by:EC Ipp RevB
11.07.26 per NCR 11-628 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-12A

Purchased

No

110

Each

155.0000

1

1

AN4-12A

Bolt

**

SEP 15 2017

68-6

9

DAS

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

145

m136199

40

m138209

105

AN4-14A

Purchased

No

110

Each

30.0000

1

1

AN4-14A

Bolt

**

SEP 15 2017

68-6

9

DAS

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

ST344

25

M137495

6

M137886

2

M138408

17

AN44-7A

Purchased

No

110

Each

8.0000

1

1

AN44-7A

Eyebolt

**

SEP 15 2017

68-6

9

DAS

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST339

8

m137371

3

m137594

5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 2

Work Order ID: 166276

166276

Parent Item: D205-633-023

D205-633-023

Parent Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-5A Purchased No 110 Each 75.0000 1 1

AN4-5A

BOLT

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST345

75

m137371

75

SEP 15 2017

DAS
28
9-89
6
9-89

AN4-6A Purchased No 110 Each 823.0000 3 3

AN4-6A

BOLT

**

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

700

M138045

500

M138207

200

ST345

123

M137951

123

SEP 15 2017

DAS
28
9-89
6
9-89

AN4-7A Purchased No 110 Each 138.0000 1 1

AN4-7A

Bolt

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST345

138

m136866

3

m137820

135

SEP 15 2017

DAS
28
9-89
6
9-89

AN5-14A Purchased No 110 Each 35.0000 1 1

AN5-14A

Bolt

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST338

35

m137699

35

SEP 15 2017

DAS
28
9-89
6
9-89

Thursday, September 14, 2017 10:24:00 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Thursday, September 14, 2017 10:24:00 AM

Page 3

Work Order ID: 166276

166276

Parent Item: D205-633-023

D205-633-023

Parent Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2022-101	Manufactured	No	110	Each	13.0000	4	4	SEP 15 2017	DAS 6 9-89	DAS 28 9-89
D2022-101						**				
Spacer										
DAS 27 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			ST001		13					
			162474		13		4			
D2022-103	Manufactured	No	110	Each	15.0000	2	2	SEP 15 2017	DAS 6 9-89	DAS 28 9-89
D2022-103						**				
Spacer										
DAS 27 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			ST001		15					
			162375		15		2			
D2562-013	Manufactured	No	110	Each	3.0000	1	1	SEP 15 2017	DAS 6 9-89	DAS 28 9-89
D2562-013						**				
Strut 26.63"										
DAS 27 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			ST353		3		1			
			159921		3					
D2563	Manufactured	No	110	Each	0.0000	1	1	SEP 15 2017	DAS 6 9-89	DAS 28 9-89
D2563						**				
Step Weldment Assembly							166278			
D2565-201	Manufactured	No	110	Each	2.0000	1	1	SEP 15 2017	DAS 6 9-89	DAS 28 9-89
D2565-201						**				
Strut										
DAS 27 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			ST354		2		1			
			160050		2					

Thursday, September 14, 2017 10:24:00 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Date : _____		Step #: _____		QTY Effective : _____			MRB (Q51042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Picklist Print

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Work Order ID: 166276

166276

Parent Item: D205-633-023

D205-633-023

Parent Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2565-211

Manufactured No

110 Each

3.0000

1 1

D2565-211

Strut

**

SEP 15 2017

DAS 6 28
9-89 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST355

3

160002

1

165594

2

D3437-043

Manufactured No

110 Each

2.0000

1 1

D3437-043

Aft Strut Assembly

**

SEP 15 2017

DAS 6 28
9-89 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST501

2

159484

2

MS21042L4

Purchased No

110 Each

1,903.000

7 7

MS21042L4

Nut

**

SEP 15 2017

DAS 6 28
9-89 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

OVER007

500

m138230

500

ST303

1393

m138084

19

m138170

500

m138326

874

Thursday, September 14, 2017 10:24:00 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Picklist Print

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Page 6

Work Order ID: 166276

166276

Parent Item: D205-633-023

D205-633-023

Parent Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No 110 Each 363.0000 2 2

MS21042L5

Nut

**

SEP 15 2017

DAS

6
9-89

DAS

28
9-89

Location

Loc Qty

Loc Code

GA	10
m127813	10
ST303	353
m137587	4
m137963	49
m138209	200
m138336	100

DAS
27
9-89

2

NAS1149D0463J Purchased No 110 Each 1,947.000 14 14

NAS1149D0463J

Washer

**

SEP 15 2017

DAS

6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	449
M135056	40
M137699	409
Return2017	16
M136665	16
ST263	1482
M137988	600
M138084	27
M138230	855

DAS
27
9-89

24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, September 14, 2017 10:24:00 AM

Page 7

Work Order ID: 166276

166276

Parent Item: D205-633-023

D205-633-023

Parent Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,292.000

3

3

NAS1149D0563.J

**

SEP 15 2017

Washer

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

36

m135774

36

ST263

1256

m138040

556

~~m138209~~

700

3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

**5.2 D205-633-021/-022/-023/-024/-025/-026 Heli-Access Step
(Simplex Model 304 Fire Attack Tank Compatible)**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
				*1	*1	D3165-1	SUPPORT ARM
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED

Shil' 26 Sept

Work Order ID 166276***166276***

Page 1

Thursday, September 14, 2017 10:24:01 AM

Item ID: D205-633-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible

Start Date: 9/19/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

SEP 13 2017

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN-D205-633

C

SEP 15 2017


100 Document Control 0.00

100

DC

DOCUMENT CONTROL

SEP 19 2017

DAS
5
9-89

Memo 0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D205-633-023 CHG001

110 Pick Kit 0.00

110

Packaging

Memo 0.00

Packaging

SEP 15 2017

DAS
6
1-30

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo 0.00

Quality Control

**Department of Transport*****Supplemental Type Certificate*****This approval is issued to:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7 Canada

Number: SH96-57**Issue No.:** 5**Approval Date:** May 13, 1996**Issue Date:** March 11, 2003**Responsible Region:**

Ontario

Aircraft/Engine Type or Model:

BELL 205A, 205A 1, 205B, 212, 214B, 214B 1, 412, 412 CF, 412 EP

Canadian Type Approval or Equivalent:

H1SW, H-104, H-86, H-80

Description of Type Design Change:

Heli-Access-Step Installation

**Installation/Operating Data,
Required Equipment and Limitations:****Installation:**

Installation of Heli-Access-Steps is to be carried out in accordance with Dart Aerospace Ltd. Drawing No. IIN-D205-633 Rev. A, dated 02.06.14, or later Transport Canada approved revision.

Required Equipment:

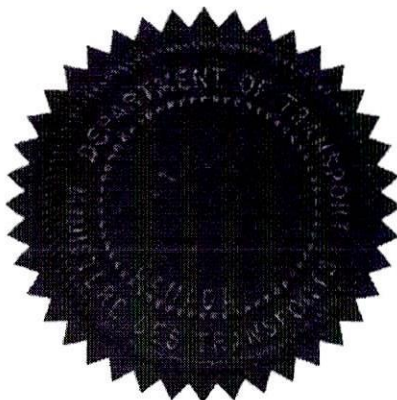
Inspection of the installation is to be performed in accordance with Dart Aerospace Ltd. Instructions for Continued Airworthiness ICA-D205-633 Rev. 0, dated 02.06.18, or later Transport Canada accepted revision.

Flight Manual Supplement FMS-D205-633, rev B, dated 03.02.24, or later Transport Canada approved revision.

Note: Compatibility of this installation has been shown with the D205-523 rappel installations approved per Canadian STC SH96-90 (ref. FAA STC SR00511NY/SR00512NY/SR00513NY)

- END -

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.





Alex. Pompei

Senior Engineer, Aircraft Certification
For Minister of Transport